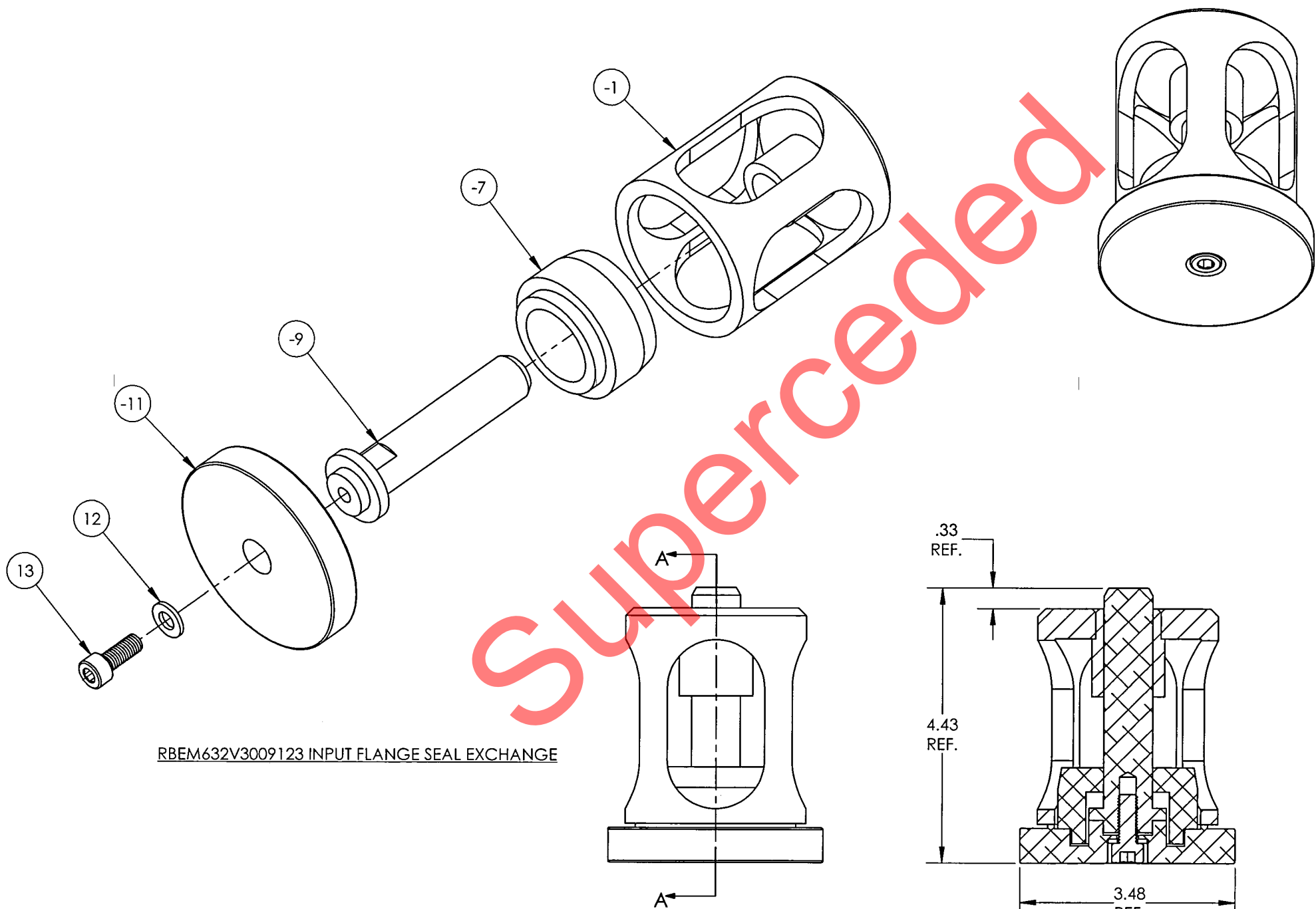


ITEM #	QTY	PART #	TITLE	PG
-1	1	RBEM632V3009123-1	FRAME WELDMENT	1
-7	1	RBEM632V3009123-7	GUIDE	4
-9	1	RBEM632V3009123-9	PIN	5
-11	1	RBEM632V3009123-11	DISC PLATE	6
12	1	McMaster#91166A270	FLAT WASHER M8 x 16 OD x 8.4 ID	-
13	1	McMaster#90128A274	SOCKET HEAD CAP SCREW M8x1.25x20MM	-

REV.	DESCRIPTION	DATE	BY	APPROVED
1	NEW ISSUE	16.05.05	C	G
B	TOLERANCES ADDED ON -3 & -5, DRAWING TEMPLATE CHANGED AS PER DART HAWKESBURY STANDARDS, -5 SHAPE CHANGE	17.09.05	VM	WM



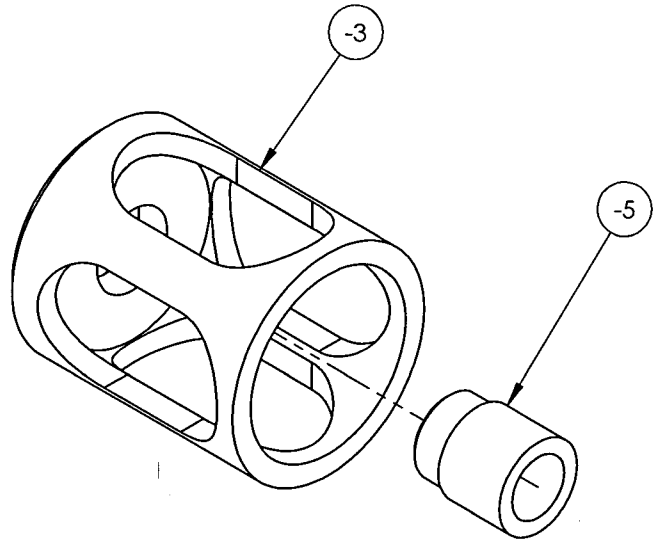
RBEM632V3009123 INPUT FLANGE SEAL EXCHANGE

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) HEAT TREAT: N/A
 - 4) SPEC: N/A
 - 5) BREAK ALL SHARP EDGES: N/A
 - 6) IDENTIFICATION: AS PER QSI 044
 - 7) REF. AIRBUS T/N M632V3009123.
 - 8) PART OF KIT RBEM632V3009103.

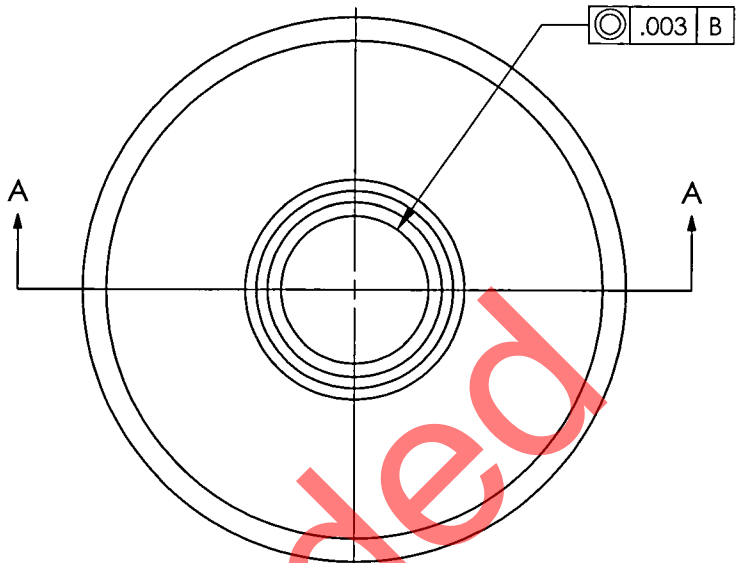
DART AEROSPACE		Hawkesbury, Ontario, Canada	
TITLE INPUT FLANGE SEAL EXCHANGE			
DWG NO. RBEM632V3009123		REV B13	
DESIGN BY:	VM 9/5/2017	.XXX ± .005	FRACTIONS ± 1/8
DRAWN BY:	VM 09/21/2017	.XX ± .01	ANGLES ± 5°
CHECKED:	SAC 09/21/2017	.X ± .1	SURFACES = 125
MFG. APPR:	DP 09/21/2017	1. DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED	
APPROVED:	WM 09/25/2017	2. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DATE:	9/21/2017	3. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE:	NTS	WEIGHT:	N/A
		SHEET 1 OF 7	
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ECN 17-672

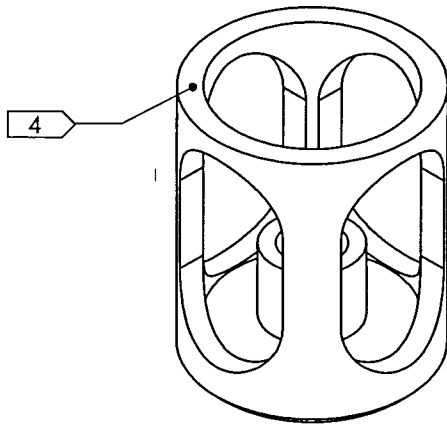
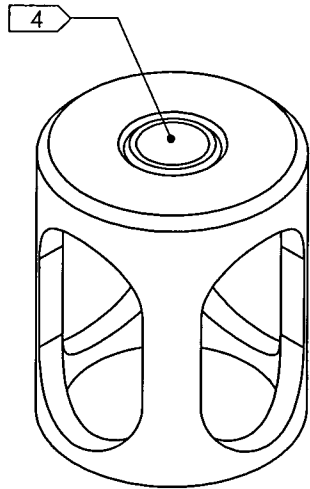
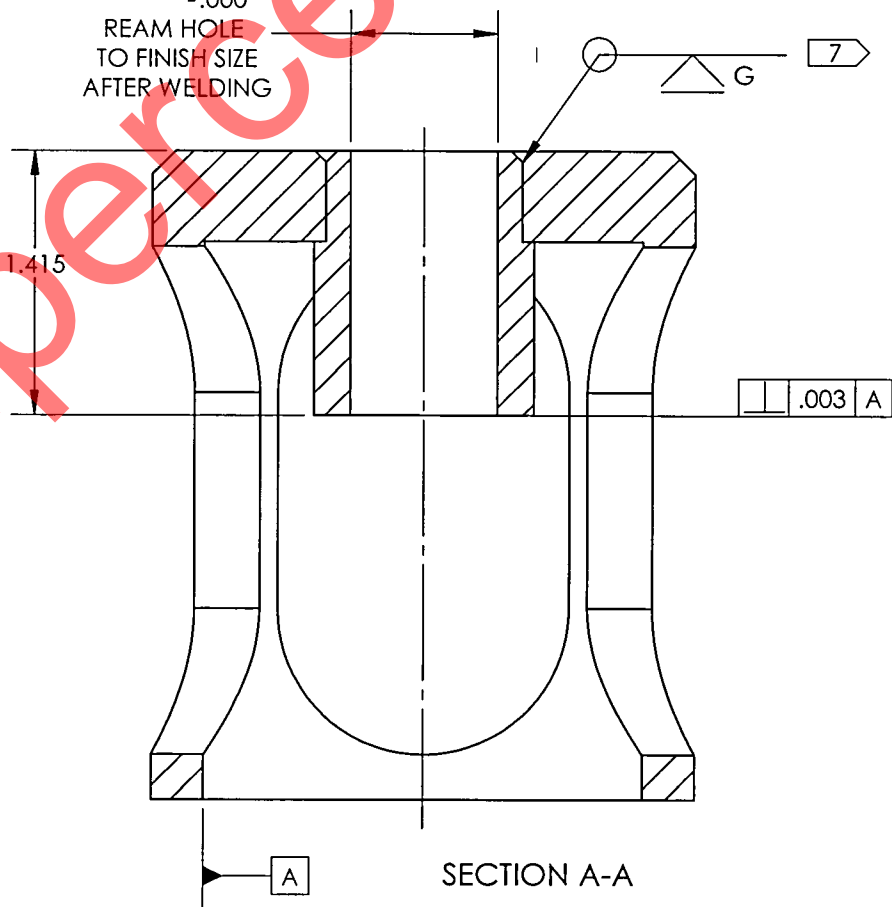
ITEM #	QTY	PART #	TITLE	PG
-3	1	RBEM632V3009123-3	FRAME	2
-5	1	RBEM632V3009123-5	INSERT	3



RBEM632V3009123-01 WELDMENT ASSY



Ø.790^{+.003}_{-.000}
REAM HOLE
TO FINISH SIZE
AFTER WELDING



- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: -1ST: CLEAR ANODIZE, MIL-A-8625F, TYPE II, CL I.
-2ND: POWDER COAT HYBRID SAFETY YELLOW, PROTECH # HS112Y12
 - 3) HEAT TREAT: N/A
 - 4) NO POWDER COAT THIS SURFACE
 - 5) BREAK ALL SHARP EDGES .015 x 45° OR .015R
 - 6) IDENTIFICATION: N/A
 - 7) WELD ACCORDING TO QSI 004

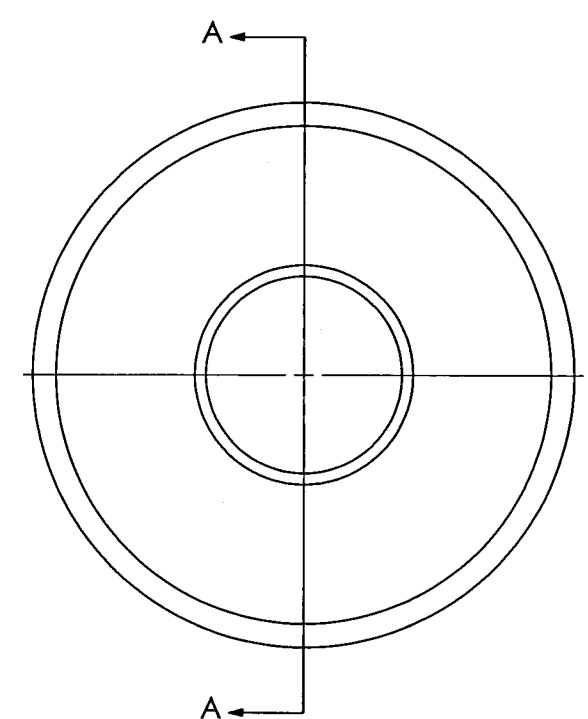
DART AEROSPACE <small>Hawkesbury, Ontario, Canada</small>			
TITLE FRAME WELDMENT			
DWG NO. RBEM632V3009123-1			REV B13
DESIGN BY:	VM 9/5/2017	.XXX ± .005	FRACTIONS ± 1/8
DRAWN BY:	VM 09/21/2017	.XX ± .01	ANGLES ± 5°
CHECKED:	SAC 09/21/2017	.X ± .1	SURFACES = 125
MFG. APPR:	DP 09/21/2017	1. DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED	
APPROVED:	WMM 09/25/2017	2. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DATE:	9/21/2017	3. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE:	NTS	WEIGHT:	N/A
			SHEET 2 OF 7
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ECN 17-672

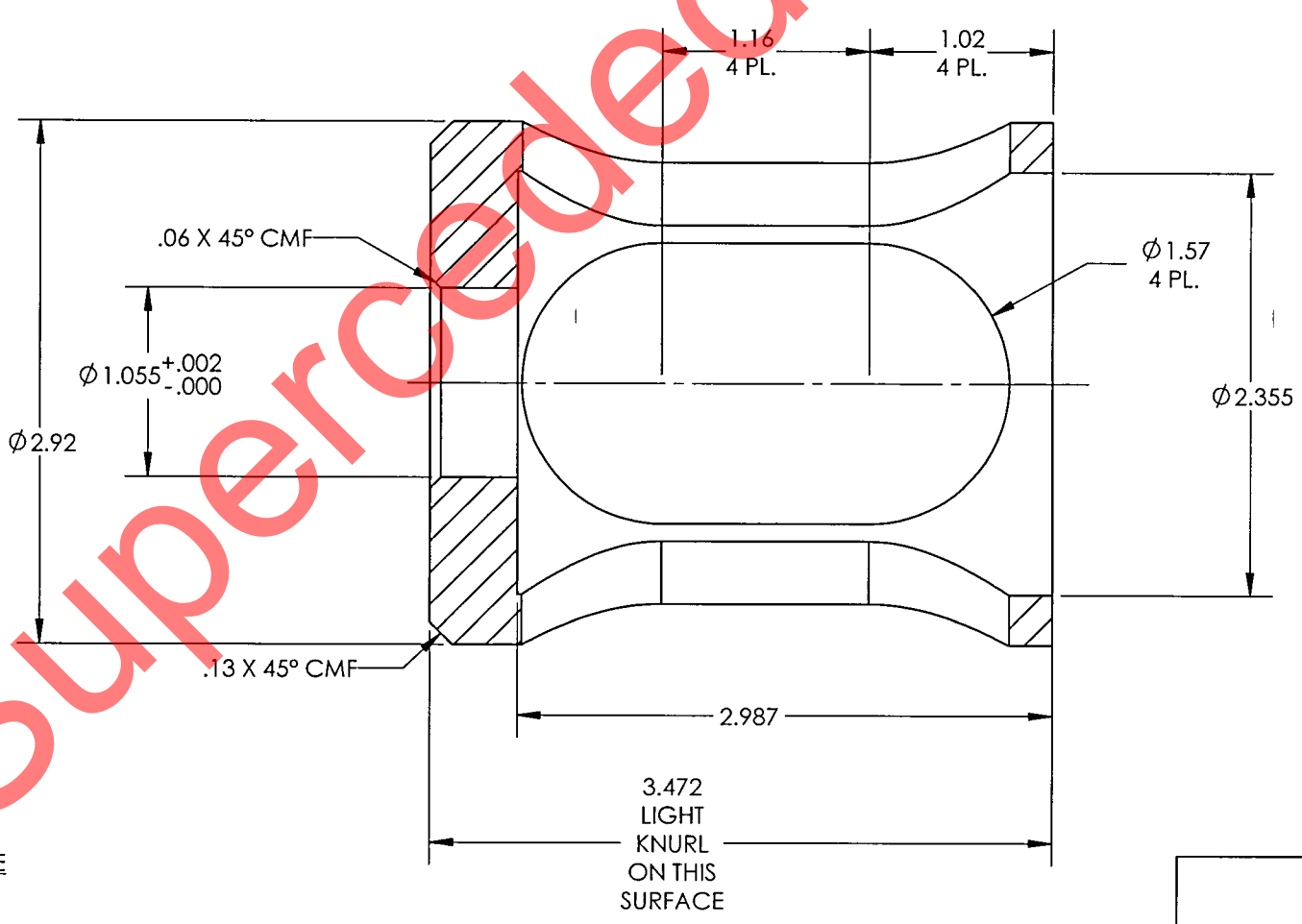
8 7 6 5 4 3 2 1

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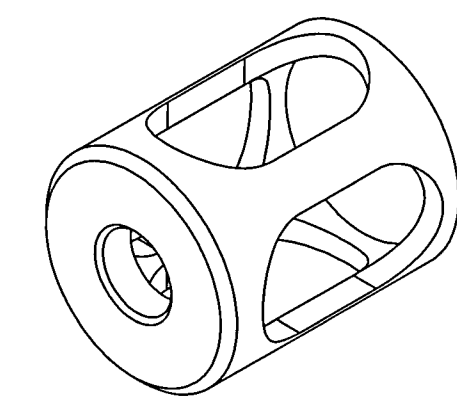
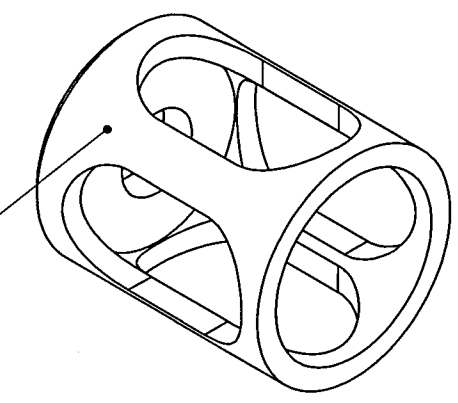
D
C
B
A



RBEM632V3009123-02 FRAME




LIGHT
KNURL
ON THIS
SURFACE



SECTION A-A

- NOTES:
- 1) MATERIAL: 6061-T6 AS PER M6061T6R
 - 2) DUAL FINISH: N/A
 - 3) HEAT TREAT: N/A
 - 4) SPEC: SEE-01
 - 5) BREAK ALL SHARP EDGES .015 x 45° OR .015R
 - 6) IDENTIFICATION: N/A

 DART AEROSPACE Hawkesbury, Ontario, Canada			
TITLE FRAME			
DWG NO. RBEM632V3009123-3			REV B13
DESIGN BY:	VM 9/5/2017	.XXX ± .005 FRACTIONS ± 1/8	1. DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED 2. INTERPRET DIM AND TOL PER ASME Y14.5M-2009 3. DIMENSIONAL LIMITS APPLY AFTER PLATING
DRAWN BY:	VM 09/21/2017	.XX ± .01 ANGLES ± 5°	
CHECKED:	SAC 09/21/2017	.X ± .1 SURFACES = 125	
MFG. APPR:	DP 09/21/2017		
APPROVED:	WM 09/25/2017		
DATE:	9/21/2017		
SCALE:	NTS	WEIGHT:	0.189LBS
		SHEET 3 OF 7	
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8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1

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D

C

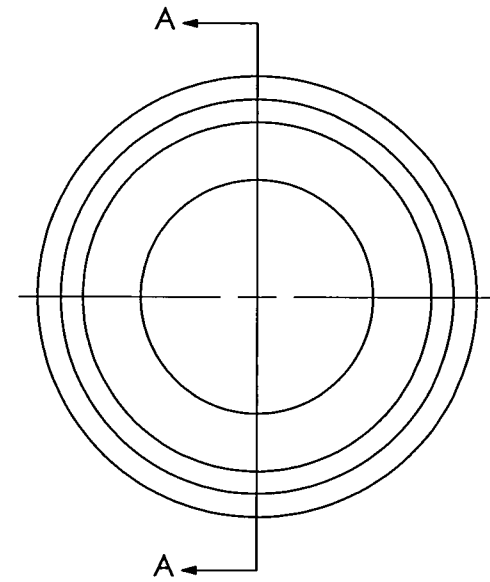
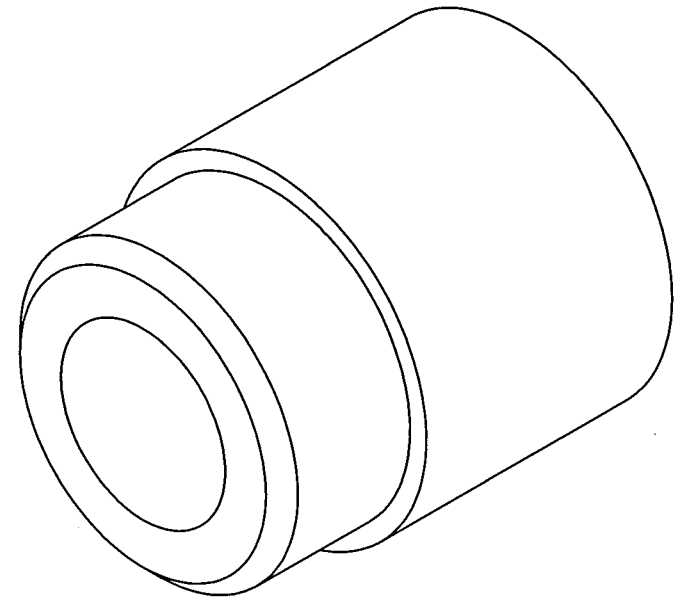
C

B

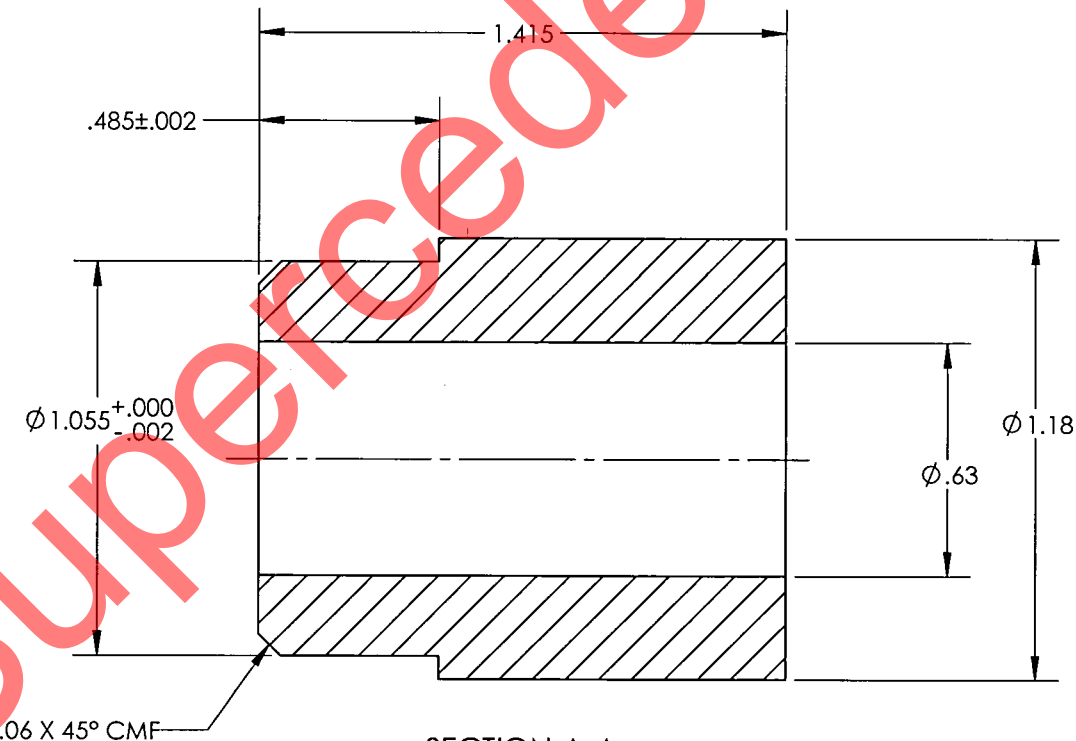
B

A

A



RBEM632V3009123-03 INSERT



SECTION A-A

- NOTES:
- 1) MATERIAL: 6061-T6 AS PER M6061T6R
 - 2) DUAL FINISH: -1ST: CLEAR ANODIZE, MIL-A-8625F, TYPE II, CL I.
-2ND: POWDER COAT HYBRID SAFETY YELLOW, PROTECH # HS112Y12
 - 3) HEAT TREAT: N/A
 - 4) SPEC: SEE-01
 - 5) BREAK ALL SHARP EDGES .015 x 45° OR .015R
 - 6) IDENTIFICATION: N/A

DART AEROSPACE Hawkesbury, Ontario, Canada			
TITLE INSERT			
DWG NO. RBEM632V3009123-5			REV B13
DESIGN BY:	VM 9/5/2017	.XXX ± .005 FRACTIONS ± 1/8	
DRAWN BY:	VM 09/21/2017	.XX ± .01 ANGLES ± 5°	
CHECKED:	SAC 09/21/2017	.X ± .1 SURFACES = 125	
MFG. APPR:	DP 09/21/2017	1. DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED	
APPROVED:	W 09/25/2017	2. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DATE:	9/21/2017	3. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE:	NTS	WEIGHT:	0.027LBS
		SHEET 4 OF 7	
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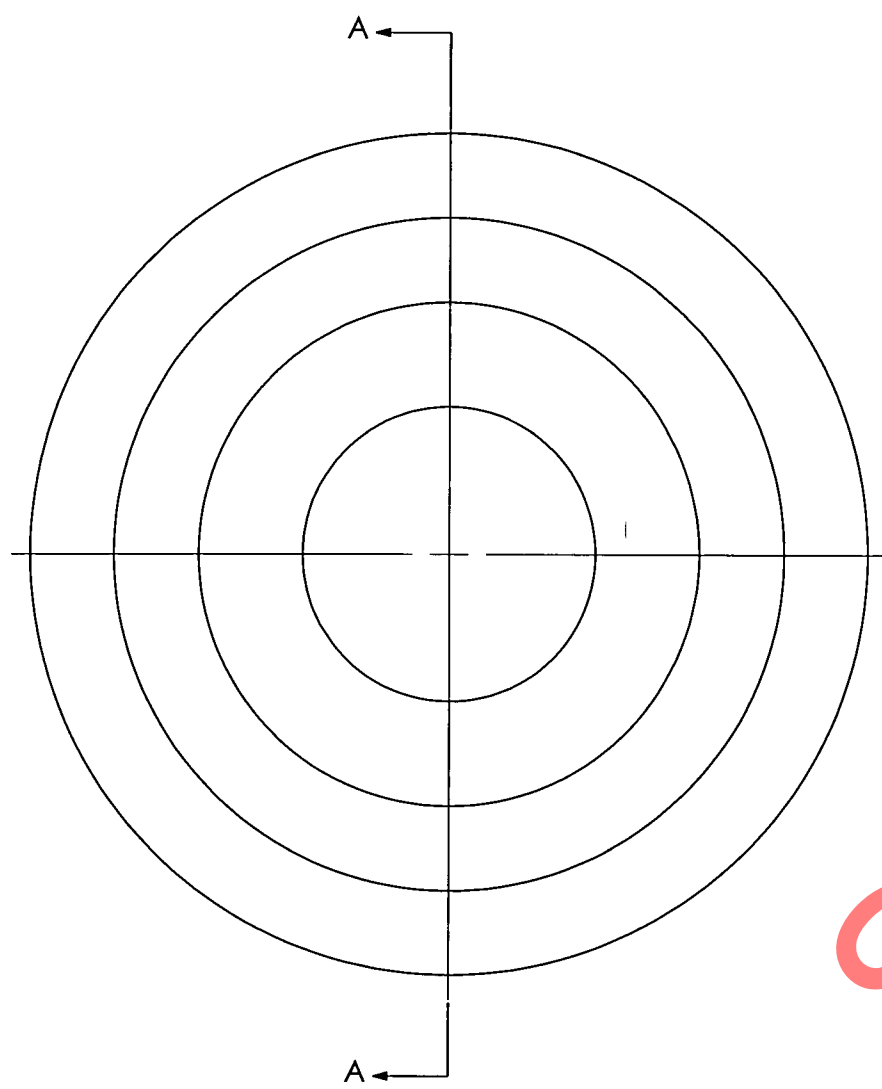
6017-672

8 7 6 5 4 3 2 1

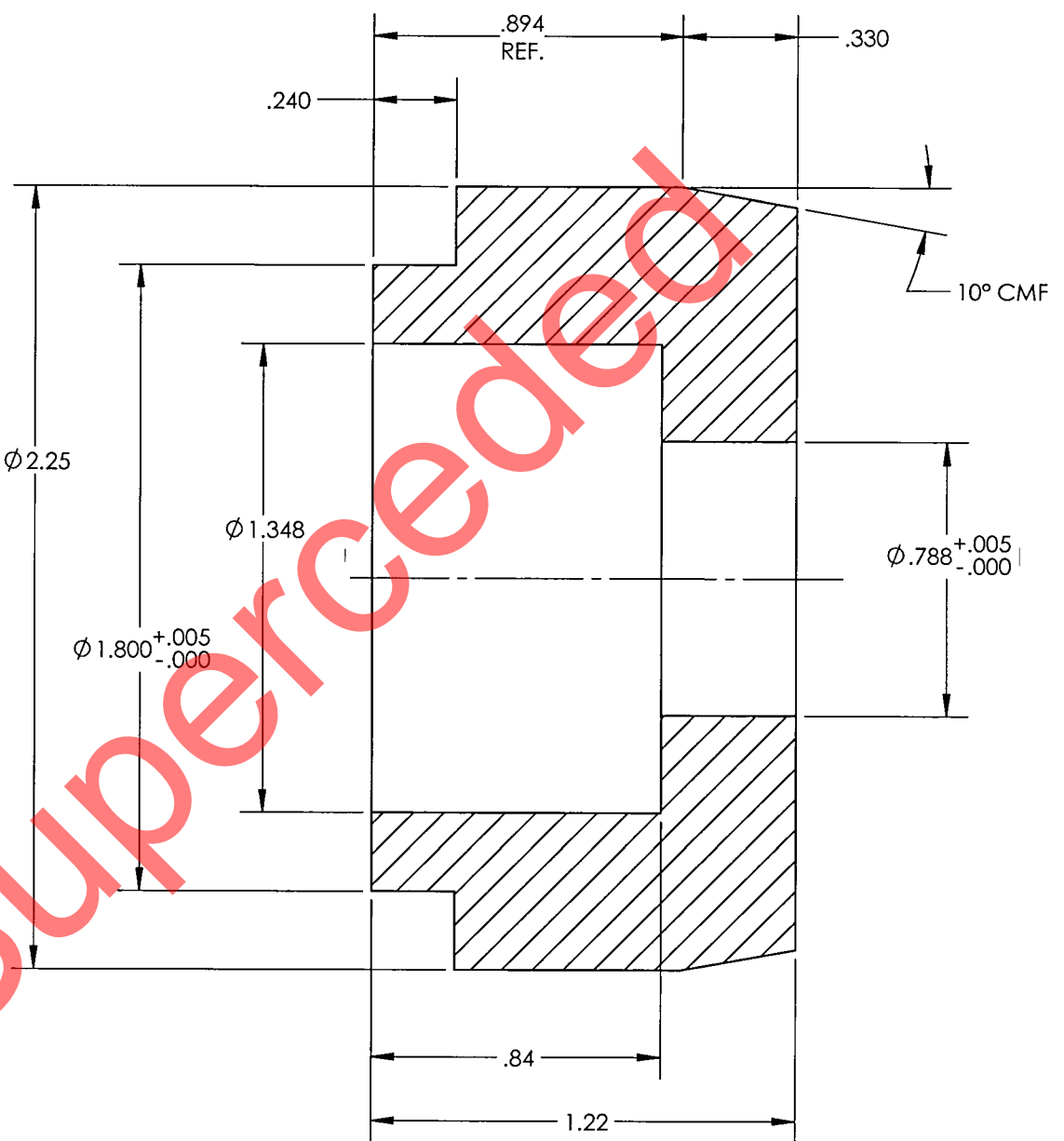
8 7 6 5 4 3 2 1

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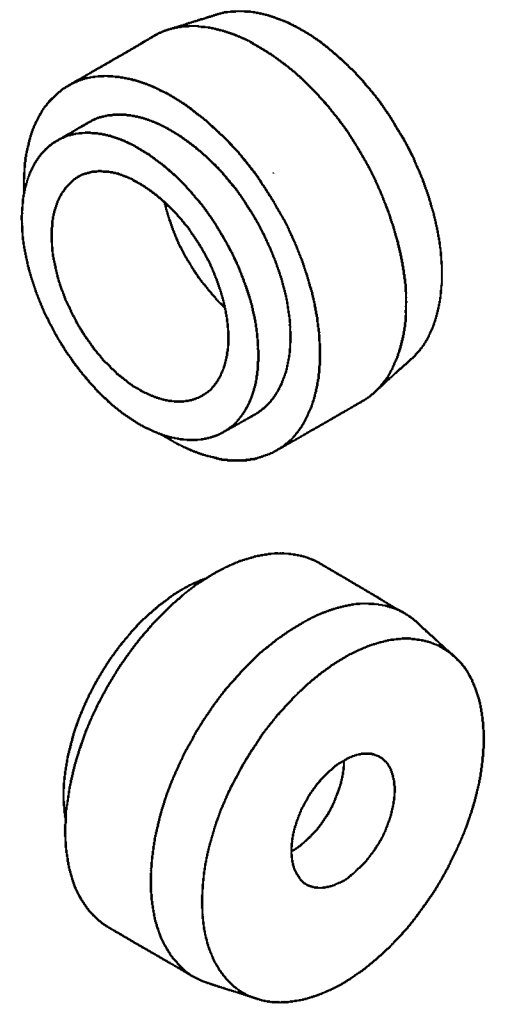
D
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RBEM632V3009123-04 GUIDE



SECTION A-A

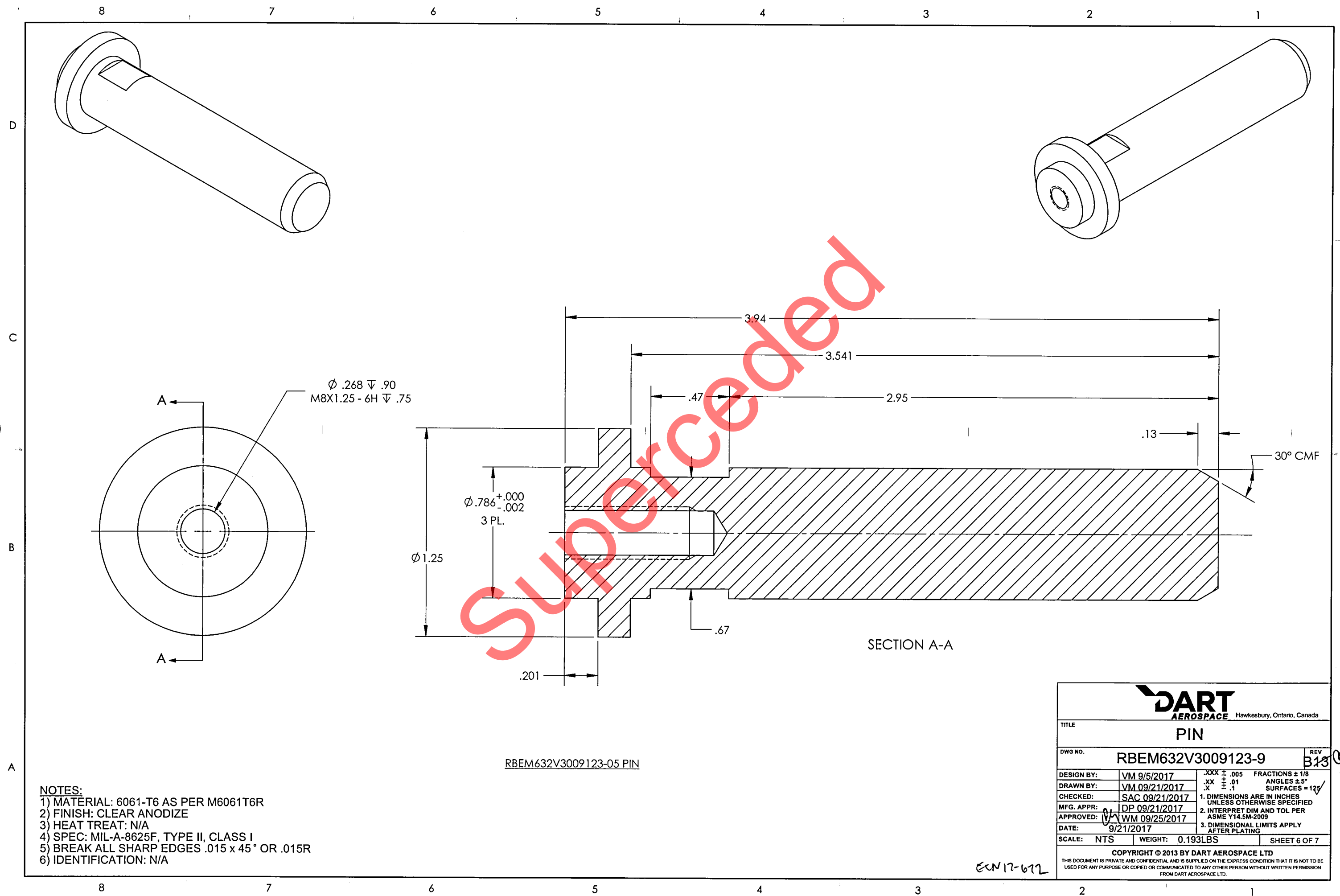


- NOTES:
- 1) MATERIAL: WHITE DELRIN/ACETRON GP AS PER M-DERLIN-R
 - 2) FINISH: N/A
 - 3) HEAT TREAT: N/A
 - 4) SPEC: N/A
 - 5) BREAK ALL SHARP EDGES .015 x 45° OR .015R
 - 6) IDENTIFICATION: N/A

DART AEROSPACE Hawkesbury, Ontario, Canada	
TITLE GUIDE	
DWG NO. RBEM632V3009123-7	REV B13
DESIGN BY: VM 9/5/2017	XXX ± .005 FRACTIONS ± 1/8
DRAWN BY: VM 09/21/2017	XX ± .01 ANGLES ± 5°
CHECKED: SAC 09/21/2017	X ± .1 SURFACES = 125
MFG. APPR: DP 09/21/2017	1. DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED
APPROVED: WM 09/25/2017	2. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DATE: 9/21/2017	3. DIMENSIONAL LIMITS APPLY AFTER PLATING
SCALE: NTS	WEIGHT: 0.157 LBS
SHEET 5 OF 7	
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ECN 17-672

8 7 6 5 4 3 2 1



- NOTES:
- 1) MATERIAL: 6061-T6 AS PER M6061T6R
 - 2) FINISH: CLEAR ANODIZE
 - 3) HEAT TREAT: N/A
 - 4) SPEC: MIL-A-8625F, TYPE II, CLASS I
 - 5) BREAK ALL SHARP EDGES .015 x 45° OR .015R
 - 6) IDENTIFICATION: N/A

RBEM632V3009123-05 PIN

DART AEROSPACE Hawkesbury, Ontario, Canada		
TITLE PIN		
DWG NO. RBEM632V3009123-9	REV B13	
DESIGN BY: VM 9/5/2017	<div>XXX ± .005 FRACTIONS ± 1/8</div> <div>XX ± .01 ANGLES ± 5°</div> <div>X ± .1 SURFACES = 125</div> <div>1. DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED</div> <div>2. INTERPRET DIM AND TOL PER ASME Y14.5M-2009</div> <div>3. DIMENSIONAL LIMITS APPLY AFTER PLATING</div>	
DRAWN BY: VM 09/21/2017		
CHECKED: SAC 09/21/2017		
MFG. APPR: DP 09/21/2017		
APPROVED: WM 09/25/2017		
DATE: 9/21/2017		
SCALE: NTS	WEIGHT: 0.193LBS	SHEET 6 OF 7
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